

Work Order ID 45536

June 29, 2009 1:07:01 PM



Page 1

Item ID: D130-780-043

Revision ID: A

Item Name: SPACEPOD LH

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-043 CHG 001

N/A

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

120

Assemble AS Per Dwg

✓

120 130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-

043 Location:

PPP Rev:

PPP 95458

For 120

6/27/09

Work Order ID 45536

June 29, 2009 1:07:01 PM



Page 2

Item ID: D130-780-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD LH

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130 150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/14

140

QC5

09/07/13

09-07-14

• Picklist Print

June 29, 2009 1:07:00 PM

Page 1

Work Order ID: 45536

Parent Item: D130-780-043RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
X AN526C832R10 		Purchased	No				Each	195.0000	2.0000			✓
Screw										104603		SP ✓
X AN526C832R10 		Purchased	No				Each	195.0000	8.0000			✓
Screw										104603		SP ✓
4 AN526C832R14 		Purchased	No				Each	1,051.000	2.0000			✓
Screw										104916		SP ✓
AN960JD10 		Purchased	No				Each	1,246.000	2.0000			✓
Washer										111668		SP ✓
AN960JD516 		Purchased	No				Each	1,603.000	1.0000			✓
Washer										111279		SP ✓
AN960JD8 		Purchased	No				Each	1,143.000	4.0000			✓
Washer										M111578		✓
AN960JD8 		Purchased	No				Each	1,143.000	8.0000			✓
Washer										M111578		✓
AN960JD8 		Purchased	No				Each	1,143.000	4.0000			✓
Washer										M111578		✓
D2228RevB 		Manufactured	No				Each	120.0000	2.0000			✓
Bracket Plate										30669		SP ✓

A3235020935 ✓ M106150

D2586 B47183

D2179 338432 ✓

D3538-1 B44650

Picklist Print

June 29, 2009 1:07:00 PM

Page 2

Work Order ID: 45536

Parent Item: D130-780-043RevA

Parent Item Name: SPACEPOD LH










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
X D2228RevB 		Manufactured	No				Each	120.0000	2.0000		30679	SP
X Bracket Plate D2464-1250RevB 		Manufactured	No				Each	0.0000	1.0000		48173	SP ✓
X Neoprene Seal D2585RevB 		Manufactured	No				Each	22.0000	2.0000		45888	SO ✓
X Mounting Channel D2586RevD 		Manufactured	No				Each	80.0000	2.0000		47183	SY ✓
X Door Latch D2589RevA 		Manufactured	No				Each	36.0000	1.0000		46840	SP ✓
X Keys, Key Chain, 350 Hinge D2621RevB 		Manufactured	No				Each	91.0000	2.0000		41175	SO ✓
X Latch Plate, 350 Spacepod D2857-1RevB 		Manufactured	No				Each	30.0000	1.0000		45788	SO ✓
X Hinge Bracket D2857-2RevB 		Manufactured	No				Each	38.0000	1.0000		43363	SO ✓
X Hinge Bracket D3015-3RevB 		Manufactured	No				Each	435.0000	1.0000		48328	SO
Locknut												

NAS 155 H3

M110397

June 29, 2009 1:07:00 PM

MS 27039-0811

M108335

Shop Packet Print

Page 2

9/7/6

10

QTY 2
QTY 2

✓
✓
W

Picklist Print

June 29, 2009 1:07:00 PM

Page 3

Work Order ID: 45536

Parent Item: D130-780-043RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
X D3186-3RevD <i>R250</i>		Manufactured	No				Each	0.0000	1.0000	<i>45092</i>		<i>SP</i>
Spacepod Door, LH										<i>57574</i>		
X D3552-7RevD		Manufactured	No				Each	16.0000	1.0000	<i>32644</i>		<i>SP</i> ✓
Door Prop										<i>35674</i>		
X D3554-7RevA		Manufactured	No				Each	81.0000	1.0000	<i>32644</i>		<i>SP</i> ✓
Ball Stud												
X D3557-1RevA		Manufactured	No				Each	18.0000	1.0000	<i>32642</i>		<i>SP</i> ✓
Bracket												
X D3837-3RevB		Manufactured	No				Each	11.0000	1.0000			
Decal										<i>1111889</i>		<i>SP</i> ✓
X MS21042L08		Purchased	No				Each	306.0000	2.0000			
Nut										<i>1111889</i>		<i>SP</i> ✓
X MS21042L08		Purchased	No				Each	306.0000	4.0000			
Nut										<i>111889</i>		<i>SP</i> ✓
X MS21042L08		Purchased	No				Each	306.0000	8.0000			
Nut										<i>111294</i>		<i>SP</i> ✓
X MS21042L3		Purchased	No				Each	1,873.000	2.0000			
Nut												

June 29, 2009 1:07:00 PM

Shop Packet Print

Page 3

AN526C 832 R24

1104603

9/1/0

14

u

Picklist Print

June 29, 2009 1:07:00 PM

Page 4

Work Order ID: 45536

Parent Item: D130-780-043RevA

Parent Item Name: SPACEPOD LH

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
X MS27039-08-11 		Purchased	No				Each	139.0000	2.0000			
Screw										108335		SP ✓
X MS27039-1-15 		Purchased	No				Each	116.0000	2.0000			
Screw										110916		SP ✓
✓ NAS1515H3 		Purchased	No				Each	530.0000	2.0000			
Washer										110397		SP ✓
										M110511 W		✓

AKS4-1032-130

June 29, 2009 1:07:00 PM

Shop Packet Print

Page 4

Date: Wednesday, 25/03/2009 11:50:13 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR ASSEMBLY, LH
Job Number :	45536		
Estimate Number :	13763		
P.O. Number :		Part Number :	D130780043
This Issue :	25/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN-D130-780
First Issue :	05/02/2009	Project Number :	N/A
Previous Run :	45535	Drawing Revision :	A
		Material :	
Written By :		Due Date :	28/02/2009
Checked & Approved By :	2009.03.25		
Comment :	Est Rev:A 09-02-03 new issue DD verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-043 CHG 001

N/A

2.0	D31863	Spacepod Door, LH
-----	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door, LH

batch: 845692

JLM

090713

3.0	D24641250	Neoprene Seal
-----	-----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Neoprene Seal

batch: _____

4.0	D38373	Decal
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: _____

5.0	D2586	Door Latch
-----	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:50:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45536

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Channel
batch: _____

7.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate, 350 Spacepod
batch: _____

8.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: 110915

9.0

NAS1149D0363J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: _____

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M111574

11.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: _____

12.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:50:14 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45536

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0



D2228

Bracket Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: _____

14.0



AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104603

JS

15.0



NAS1149DN832J

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: _____

16.0



MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M111889

JS

17.0



D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: ~~32647~~ 32647

JS

18.0



D2228

Bracket Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: 30669

19.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: 37674

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:50:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45536

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149D0563J

Washer



AN960JDS16



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: 111279

21.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch:

22.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104916

23.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 104603

24.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M111193

25.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M111899

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg

[Signature]

090708

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090713	26	Modify inside BOTTOM edge 902 cloth FG78/050550 M11166 .3yd 9330 Hysol M112165 SEE DS EMAIL ATTACHED		090713		 G. G. B. P.V. QSI 042	S 0910213	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090713	26							

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:50:14 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45536

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC5

INSPECT WORK TO CURRENT STEP



(P12) →

Comment: INSPECT WORK TO CURRENT STEP

509/02/13

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

pick kit:

29.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Keys, Key Chain, 350 Hinge

Batch: _____

30.0 ✓

D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Prop

batch: _____

31.0 ✓

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

→ 32.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 11193 111359

33.0 ✓

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/3/13	# 271	Wing - walk down side to top surface as per Draw. 3186 M 111013	JK	09-09-13	①		S 09/09/13	
9/7/13	272	QCS inspect powder coat JK	JK	09-09-13	(X)		S 09/09/13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:50:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, LH

Job Number: 45536

Part Number: D130780043

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0



MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M111889

35.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-043

Location: _____

PPP Rev: _____

37.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

	-041	-042	-043	-044	-011	-013	Part Number	Description
	X						D130-780-041	SPACEPOD™ LH, EC 130 B4
		X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1	1		X				D130-780-043	DOOR ASSEMBLY, LH
		1		X			D130-780-044	DOOR ASSEMBLY, RH
2	1				X		D130-780-011	AFT LH DOOR HINGE KIT
3	1	1				X	D130-780-013	SWITCH RELOCATION KIT
4	2	2					D3815-041	WEB ASSEMBLY
							D2464-0360	NEOPRENE SEAL
			1	1			D2589	KEYS, KEY CHAIN
5	1	1					D3837-1	DECAL
6	1	1					D3015-3	LOCK NUT
			1				D3186-3	SPACEPOD™ DOOR, LH
				1			D3186-4	SPACEPOD™ DOOR, RH
7	1						D3798-041	FLOOR
		1					D3798-042	FLOOR
8	1						D3188-5	SPACEPOD™ BODY
		1					D3188-6	SPACEPOD™ BODY
9	1	1					D3547-1	BRACKET
10	1	1					D3550-1	STRUT
			1	1			D3552-7	GAS SPRING
11	1	1					D3554-7	BALL STUD
12	4	4					AN3-3A	BOLT
13	4	4					AN3-6A	BOLT
14	2	2					AN3-10A	BOLT
15	1	1					AN5-5A	BOLT
16	38	38					AN525-10R7	SCREW
17	8	8					AN526C832R14	SCREW
18	7	7					MS24694S67	SCREW
19	1	1					MS24694S69	SCREW
			2	2			MS27039-0811	SCREW
20	8	8					A3235-020-935	WASHER
21	8	8					NAS1149D0363J	WASHER
22	16	16					NAS1149D0332J	WASHER
			4	4			NAS1149DN832J	WASHER
23	3	3					NAS1149D0563J	WASHER
			2	2			NAS1515H3	NYLON WASHER
			2	2			MS21042L08	NUT
24	16	16					MS21042L3	NUT (or MS21042-3)
25	1	1					MS21042L5	NUT
26	10	10					AKS7-1032-130	INSERT
27	28**	28**					AKS7-1032-130	INSERT
						2	D3819-1	MALE SPADE CONNECTOR
						2	D3597-1	FEMALE SPADE CONNECTOR

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Revision: A

Date: 08.10.07

45520

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Revision: A

Date: 08.10.07

NO. 45524

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

*Pre-installed on D3186-3/-4 Spacepod™ Door

**Pre-installed on D3188-5/-6 Spacepod™

***Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: **A**

Date: 08.10.07

NO. 25524

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 1 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

RELEASED**07.04.09****GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN
- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501
- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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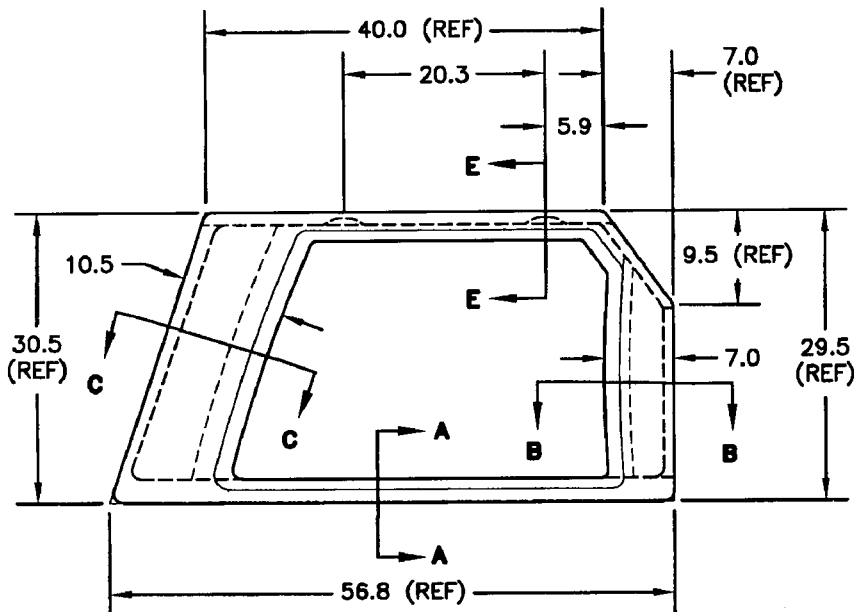
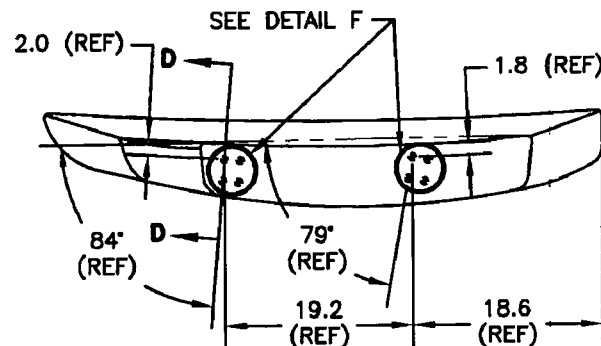
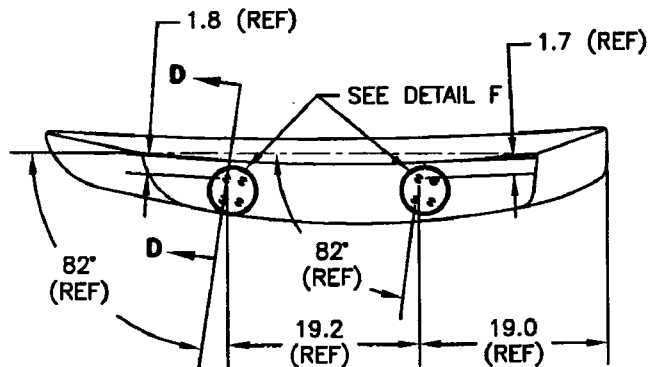
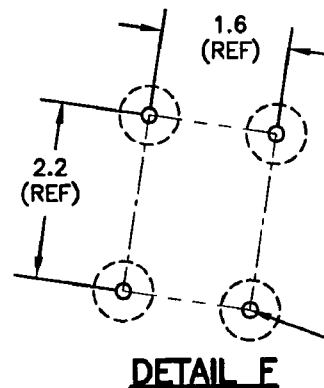
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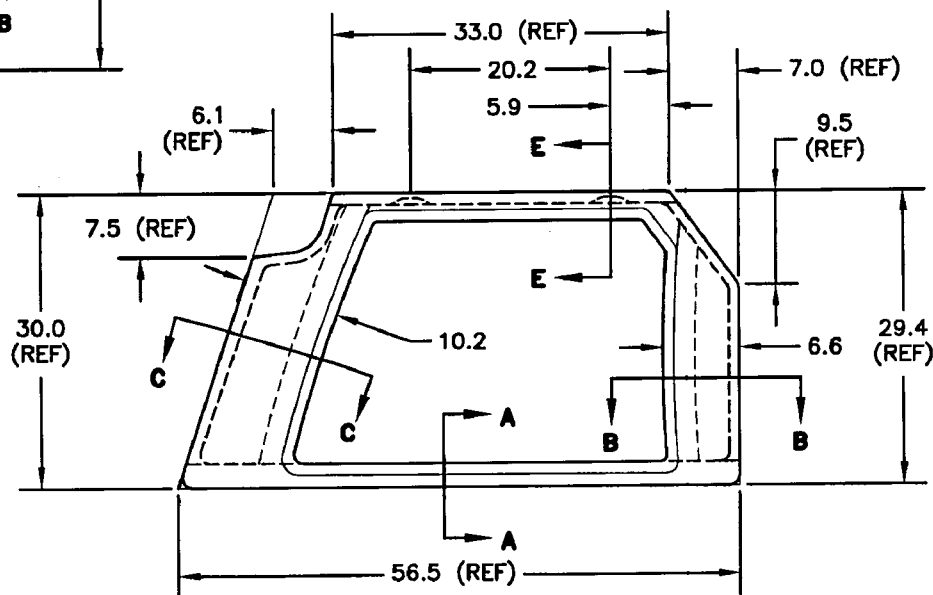
RELEASED

07-04-01

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

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DATE	07.04.02	DRAWING NO.	D3188	REV. E.
TITLE	SPACEPOD BODY	SHEET	2 OF 11	SCALE
				NTS

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D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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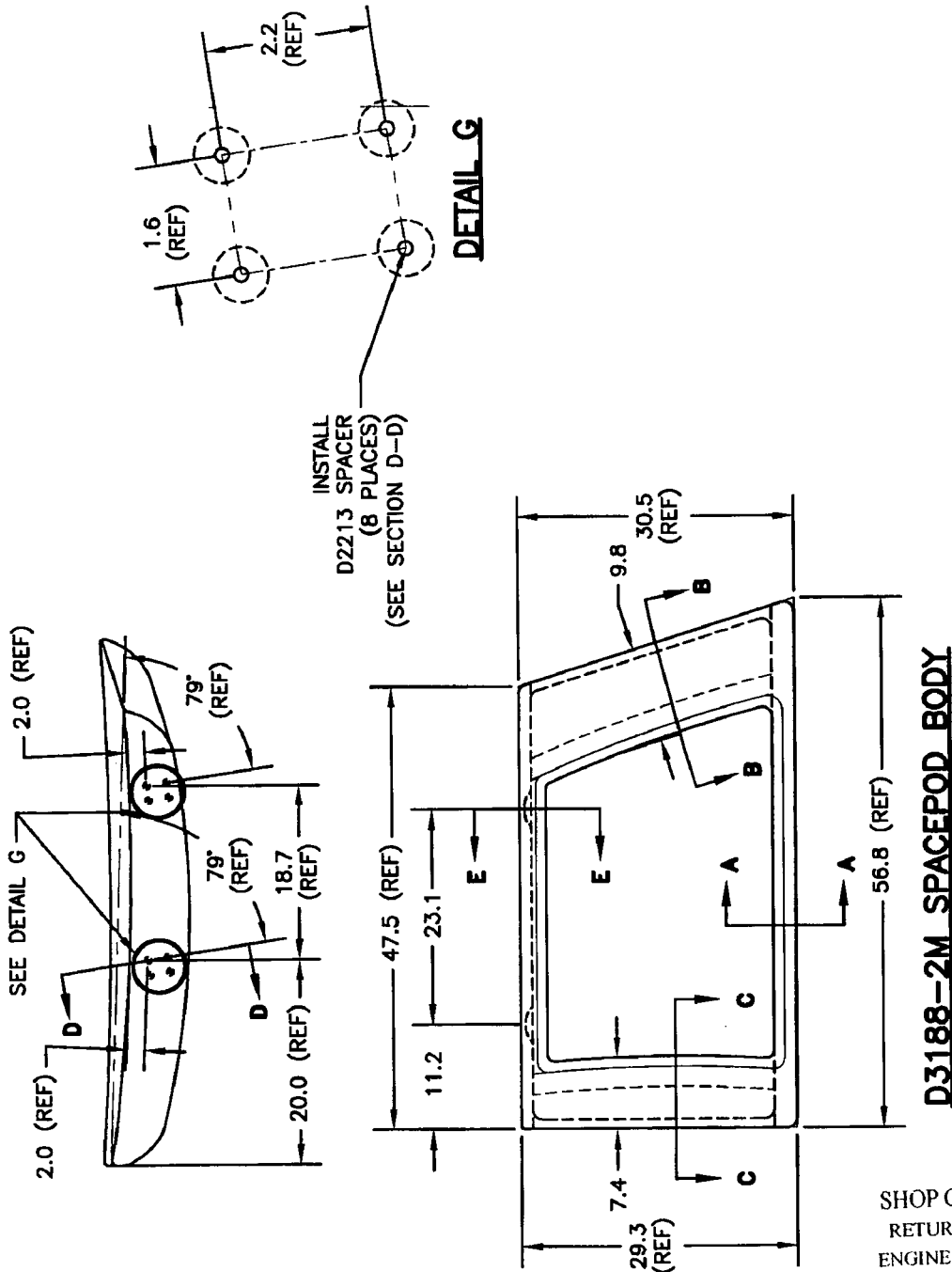
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.01 [Signature]



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D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

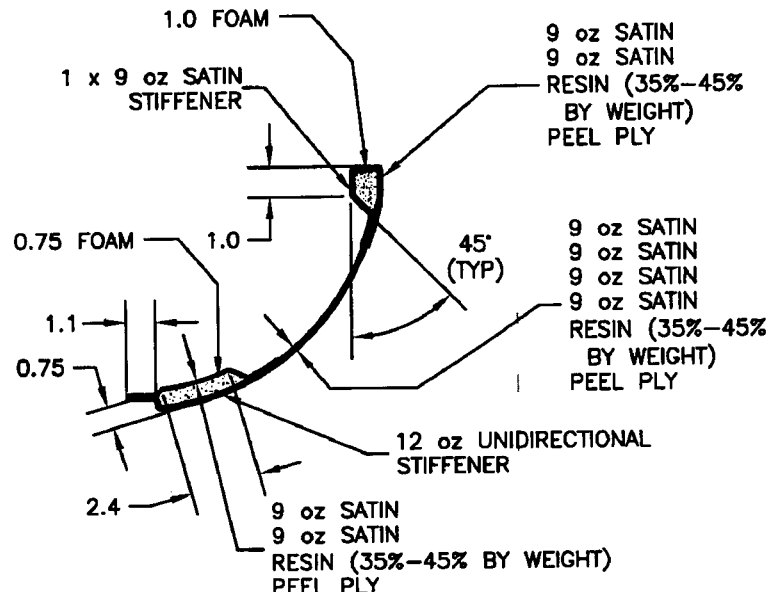
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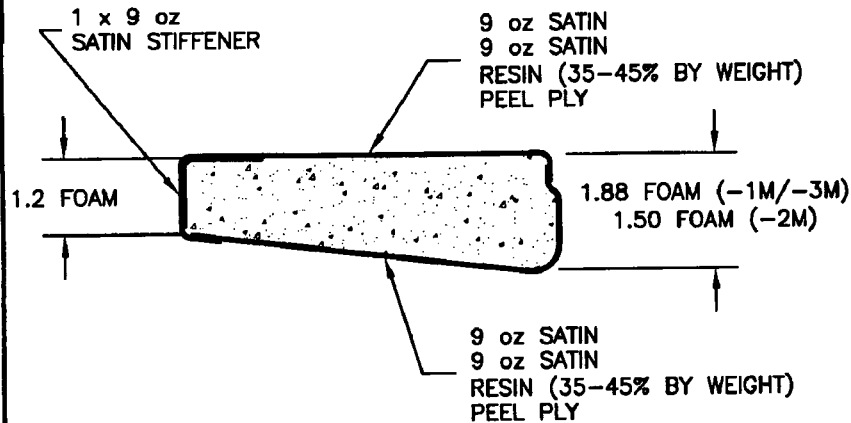
DART

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CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET	4 OF 11
		SCALE	NTS	REV. E.	

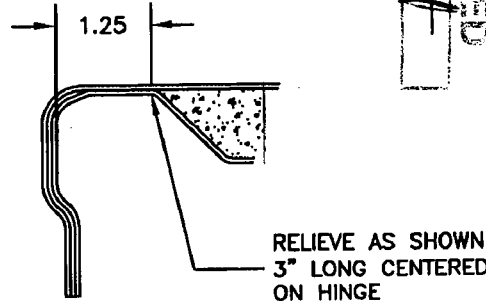
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07.04.01



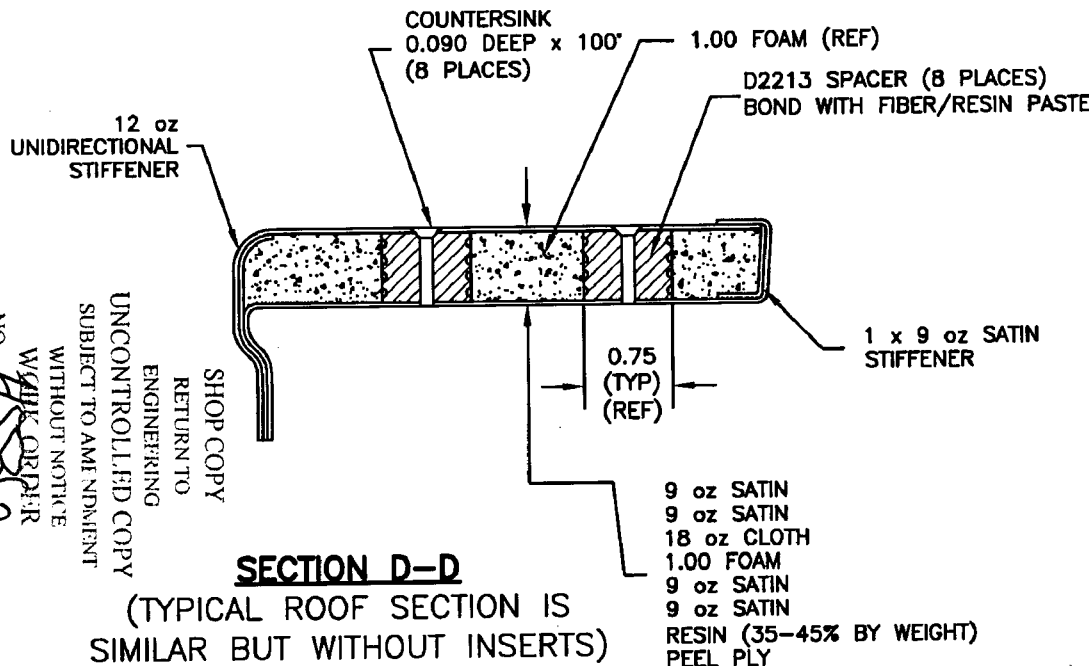
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION E-E
(2 PLACES PER POD)



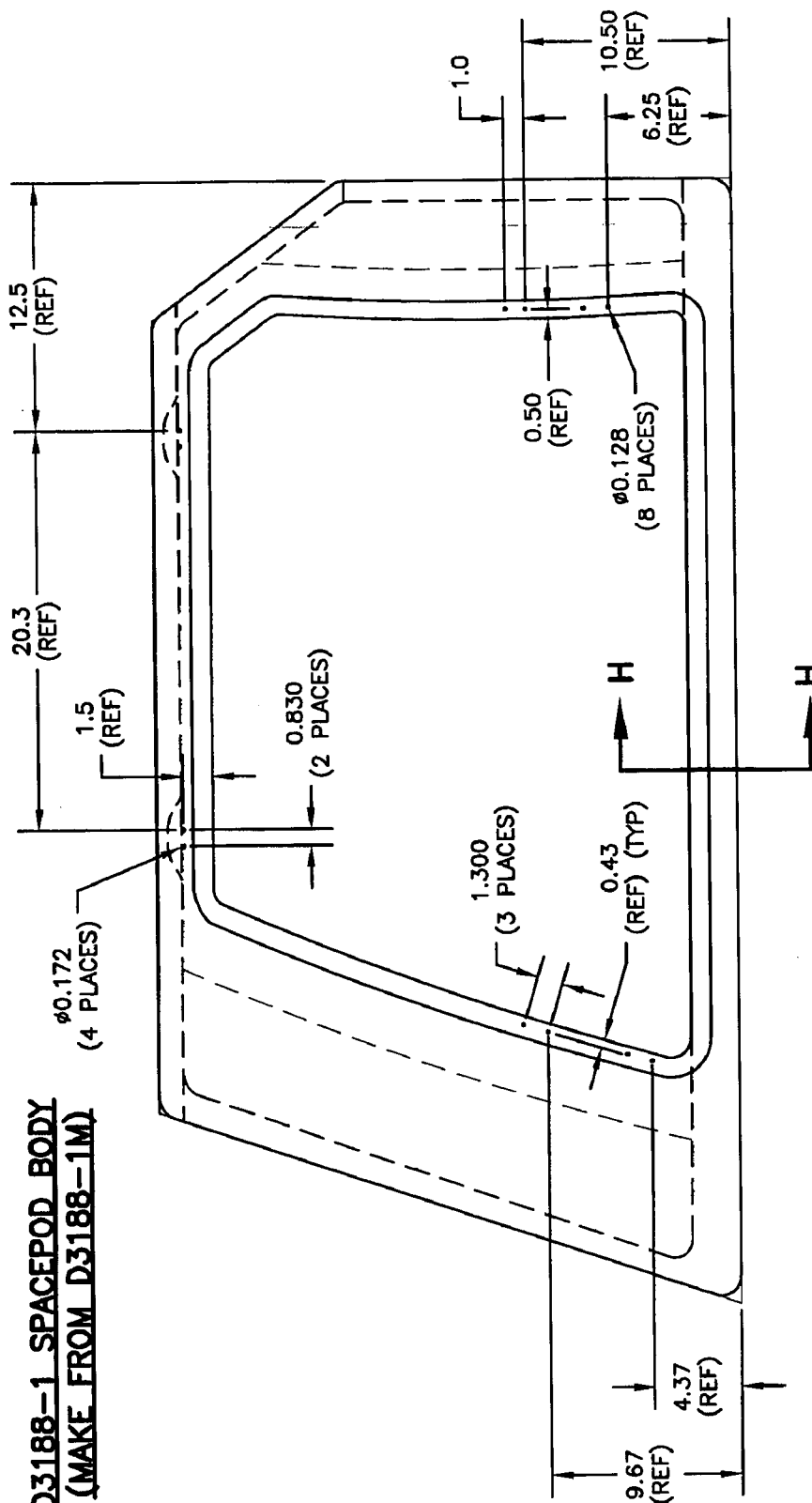
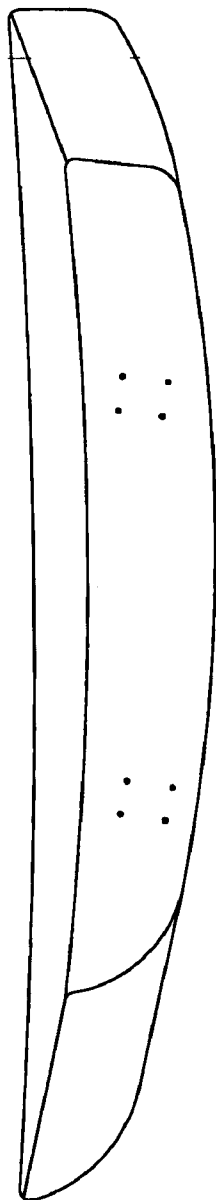
SECTION D-D
(TYPICAL ROOF SECTION IS SIMILAR BUT WITHOUT INSERTS)

DART

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

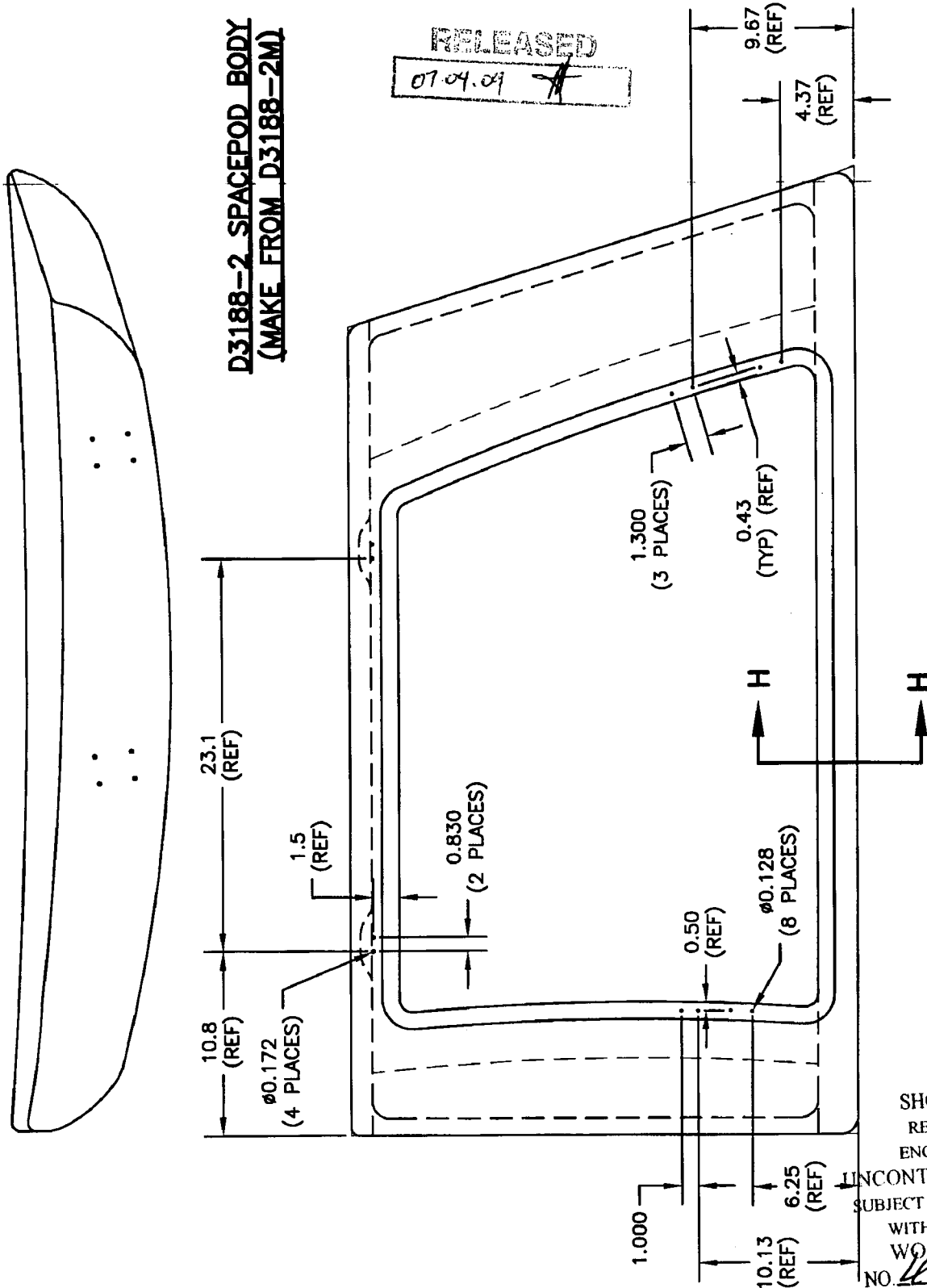
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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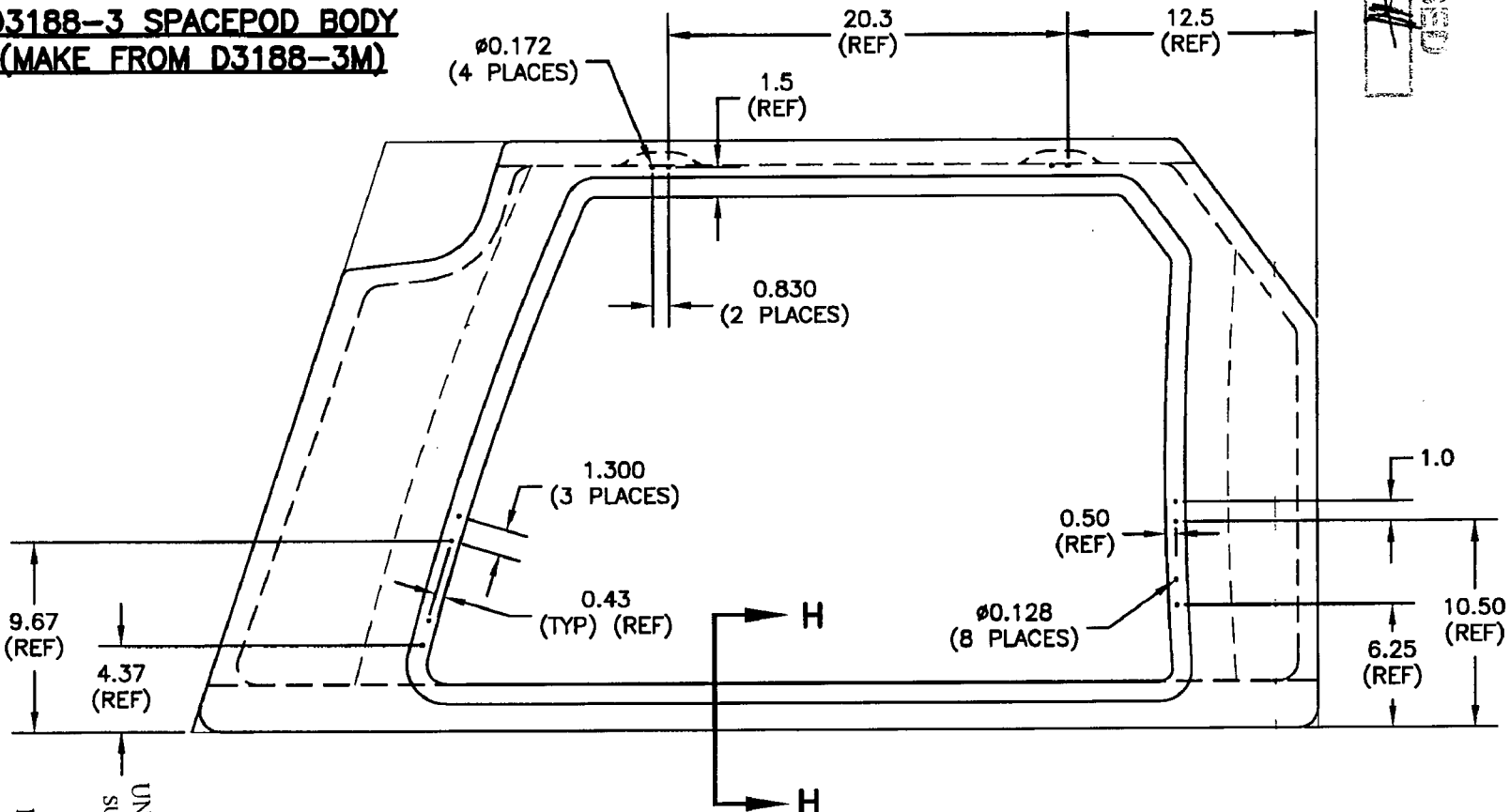
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JB	CB		REV. E
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CE	[Signature]	D3188	
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

FILED
07.04.09

D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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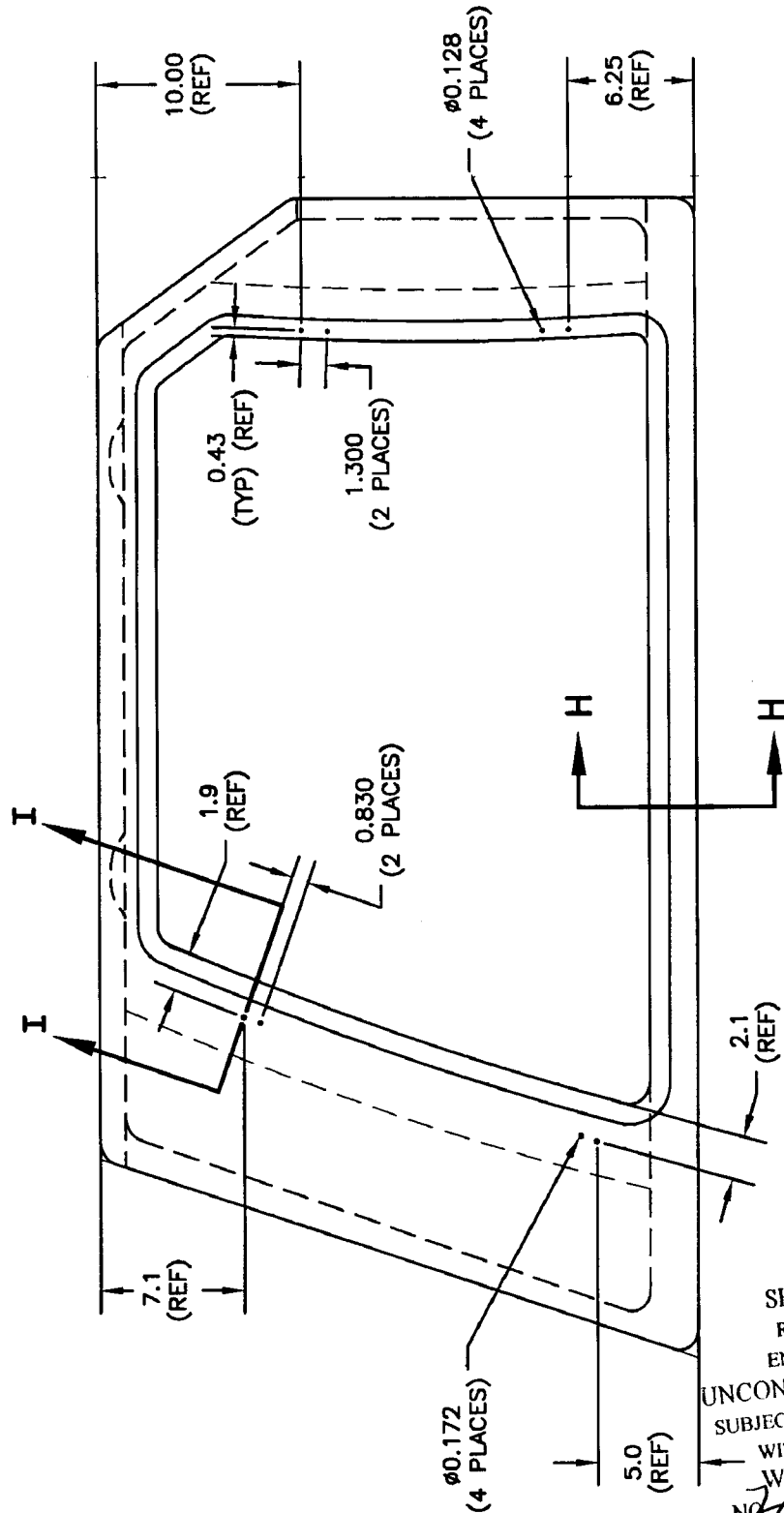
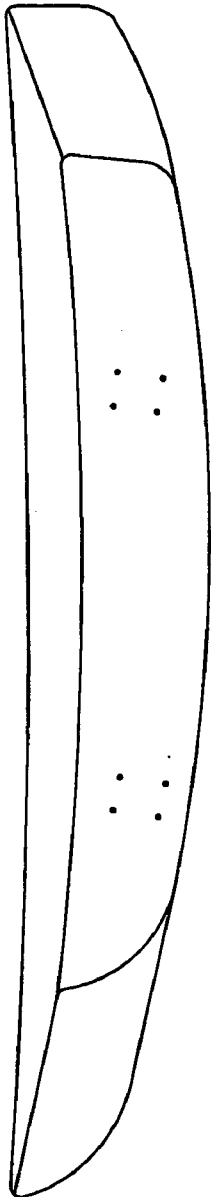


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.09 [Signature]

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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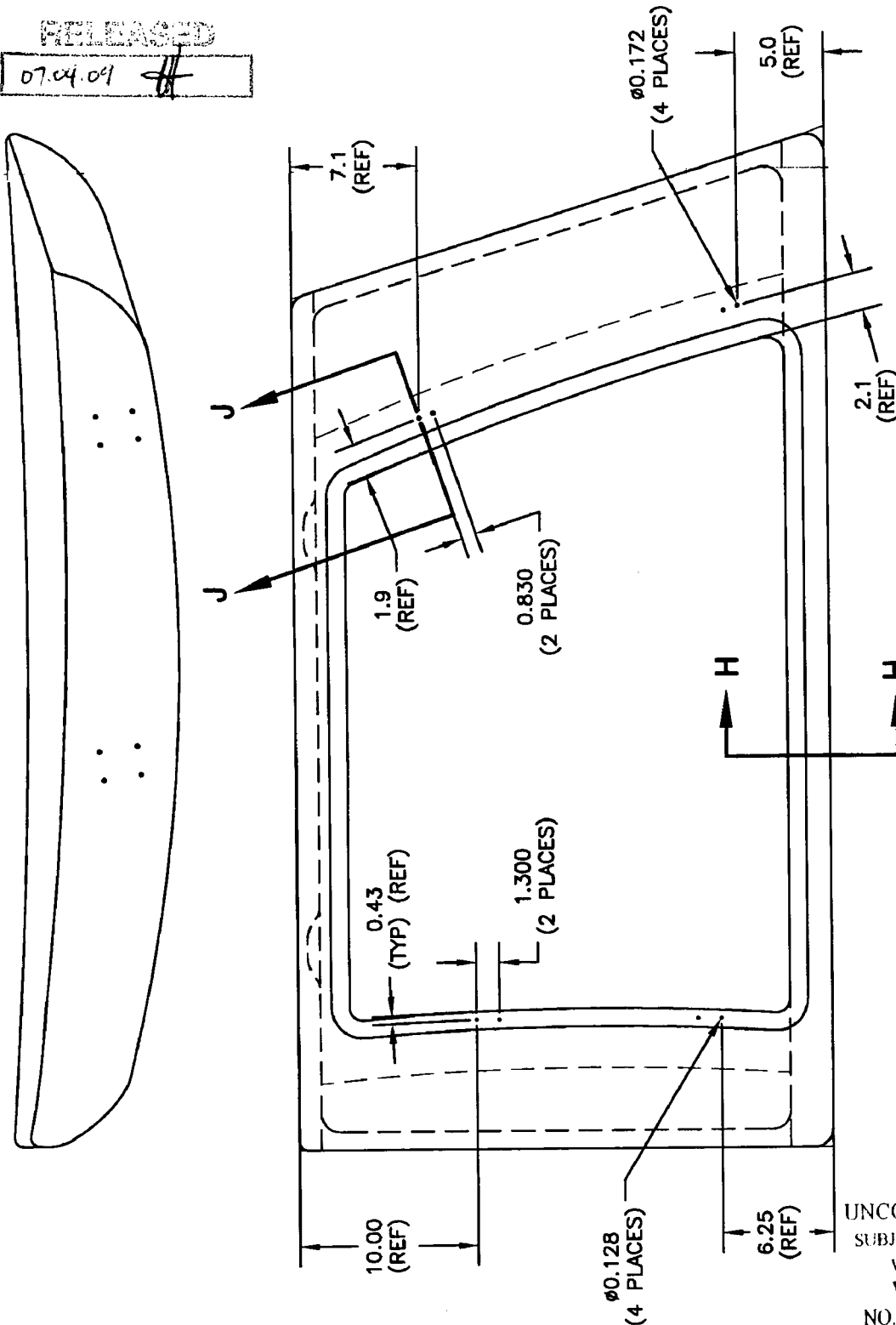
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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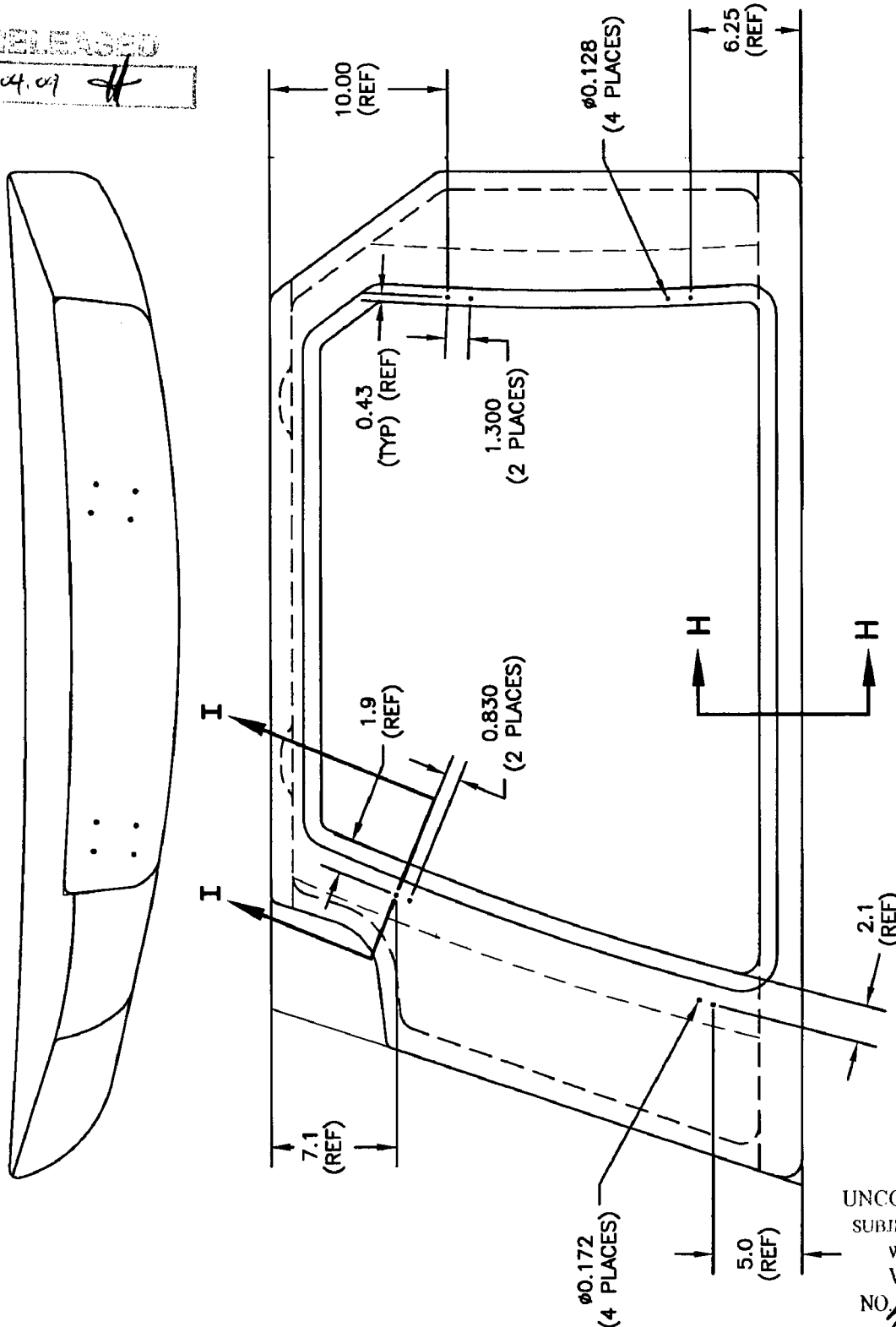
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.04.02 **[Signature]**

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #111 FOR SECTION VIEWS

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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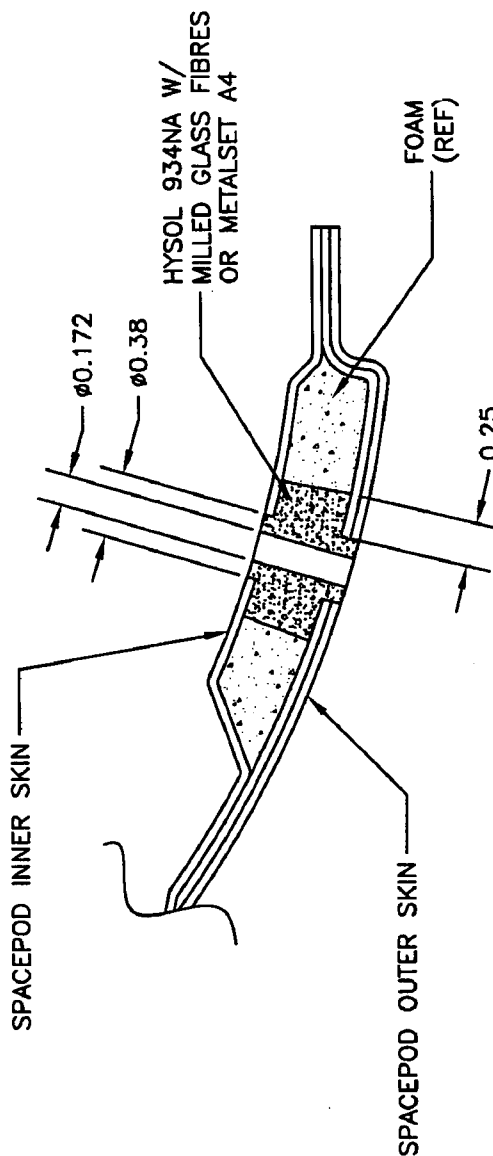
01.04.09 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]

Sent: July 13, 2009 10:58 AM

To: 'Chris Provencal'

Subject: RE: W/o chg D130-780-041/-042

Yes ... This is an acceptable modification. The drawing is in the process of being updated to reflect this chamfer.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]

Sent: Monday, July 13, 2009 8:47 AM

To: 'David Shepherd'

Subject: W/o chg D130-780-041/-042

David,

For the D130-780-041/-042, Russ has cut a 0.6" high x 2.0" wide chamfer along the lower-inboard edge. He then layed-up (2) layers of 9oz cloth with Hysol 9330 resin. This was necessary for compatibility with the 130. Is this an acceptable mod?

Sincerely,

Christopher Provencal

DART Aerospace Ltd.

cprovencal@dartaero.com

Tel: (613) 632 5200

Fax: (613) 632 9311

Checked by AVG - www.avg.com

Version: 8.5.375 / Virus Database: 270.13.12/2235 - Release Date: 07/13/09 05:56:00